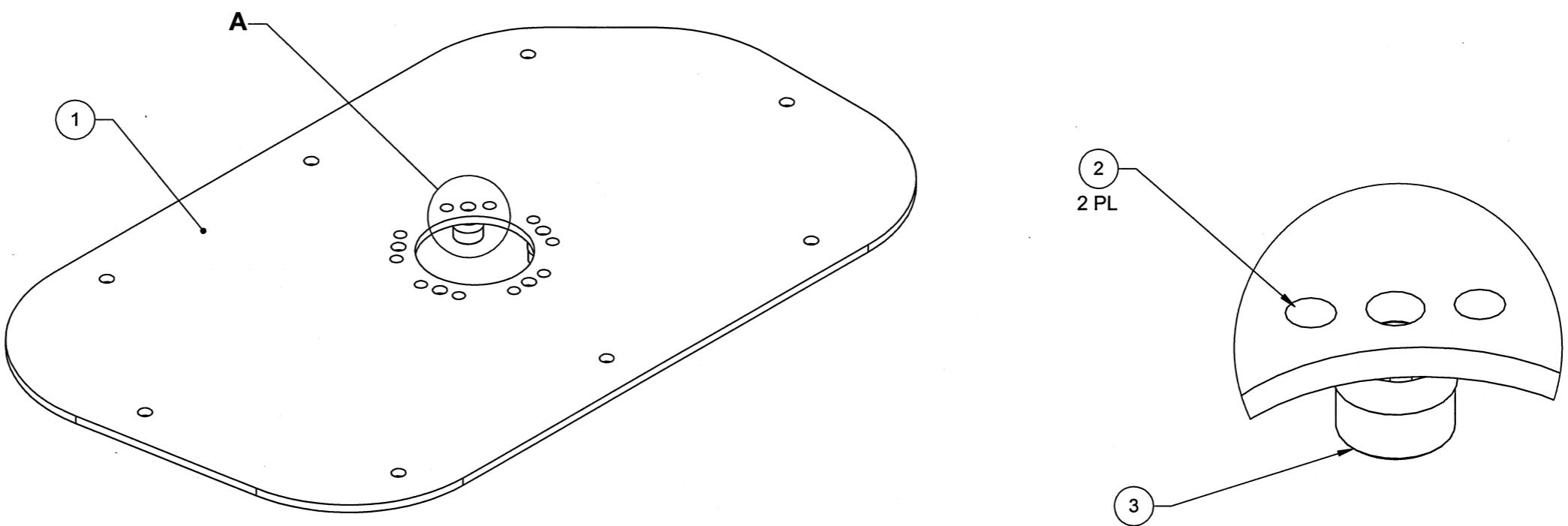


ITEM	QTY -041	P/N	DESCRIPTION
	X	D4577-041	FWD ACCESS PANEL ASSEMBLY
1	1	D4577-5	FWD ACCESS PANEL
2	10	MS20426AD3-5	RIVET, SOLID, CSK
3	5	NAS1474R3	ANCHOR NUT (OR NAS1474A3 OR NAS1474S3 OR NAS1474F3)



D4577-041 FWD ACCESS PANEL ASSEMBLY

RELEASED

2019 OCT 07
ECN 14-032 4

APPROVED

NOTES:
 1) MATERIAL: N/A
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: NONE
 7) WEIGHT: 1.08 lbs

D	ADDED D4577-7/-9/-11/-043 ACCESS PANELS, ADDED NOTE 8 (ZN A8-3,4,5). REF PAR15-432, D5473-5 WAS D4025-5 (ZN C1-5)	PM	19.02.05
C	REMOVED POWDER COAT FINISH ON ALL PARTS (SHT 1-3); FORMAT UPDATED; REVISED WEIGHT (SHT 1); VARIOUS MINOR DIMENSIONAL CHANGES, ALL PARTS NOW FULLY DIMENSIONED; REMOVED UNNECESSARY VIEWS	AP	14.12.05
B	REMOVE D4001-1; ADD NAS1474R3, ZN C2-1. MODIFY -5 FOR HARDWARE, ZN C5-4. INCREASE THICKNESS OF -1/-3/-5; IS 0.125", WAS 0.063". MODIFY DIMS OF -1/-3/-5.	DC	12.03.30
A	NEW ISSUE	DC	12.01.30
REV.	DESCRIPTION		
DESIGN	AP	DART AEROSPACE LTD	
DRAWN	PM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SAD	DRAWING NO.	REV. D
MFG. APPR.	JFS	D4577	
APPROVED	VS	TITLE	SCALE
DE APPR.	DS	ACCESS PANEL	
DATE	19.02.05	NTS	
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1

ITEM	QTY	P/N	DESCRIPTION
	X	D4577-043	FWD ACCESS PANEL ASSEMBLY
1	1	D4577-11	FWD ACCESS PANEL
2	10	MS20426AD3-5	RIVET, SOLID, CSK
3	5	NAS1474R3	ANCHOR NUT (OR NAS1474A3 OR NAS1474S3 OR NAS1474F3)

D

D

C

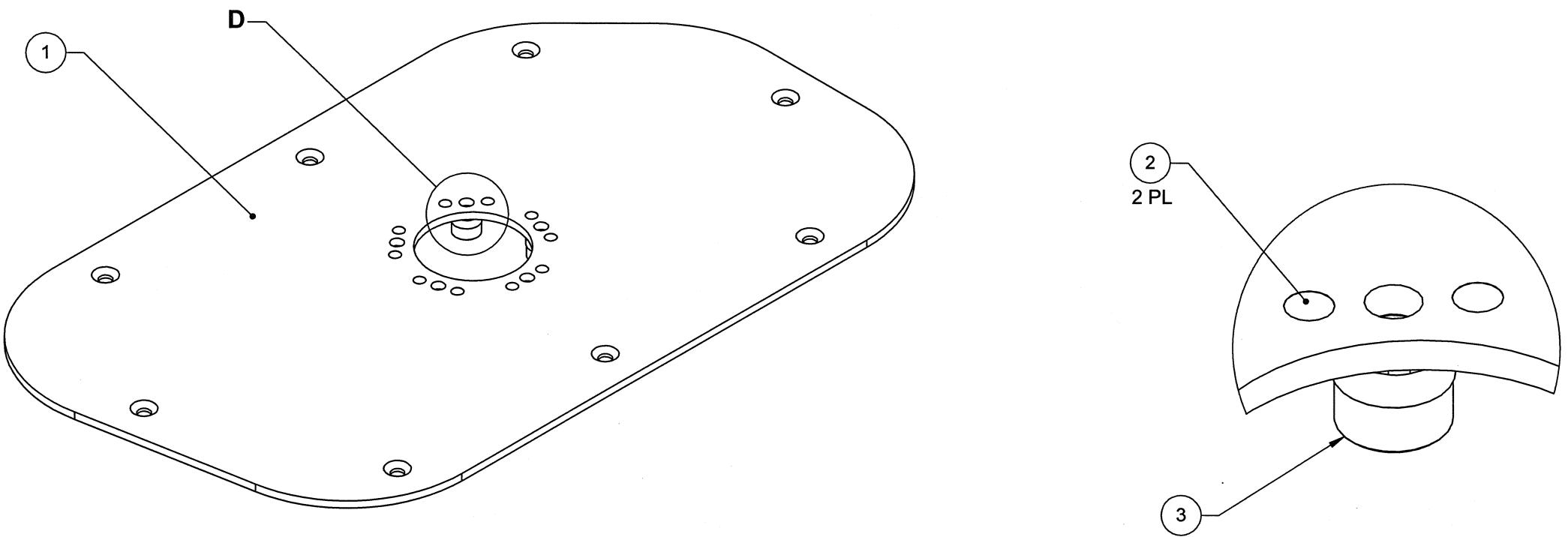
C

B

B

A

A



D4577-043 FWD ACCESS PANEL ASSEMBLY

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 1.08 lbs

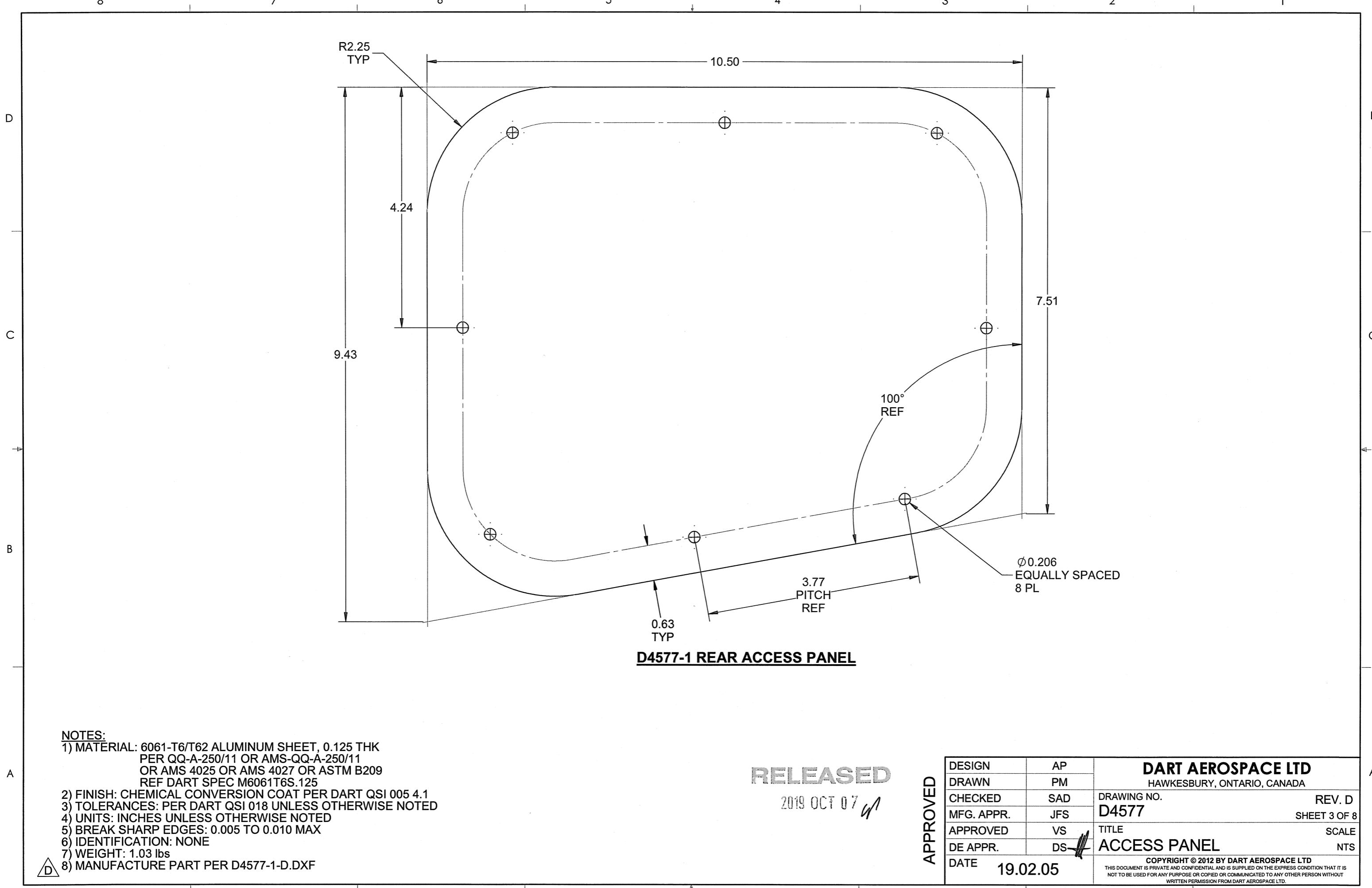
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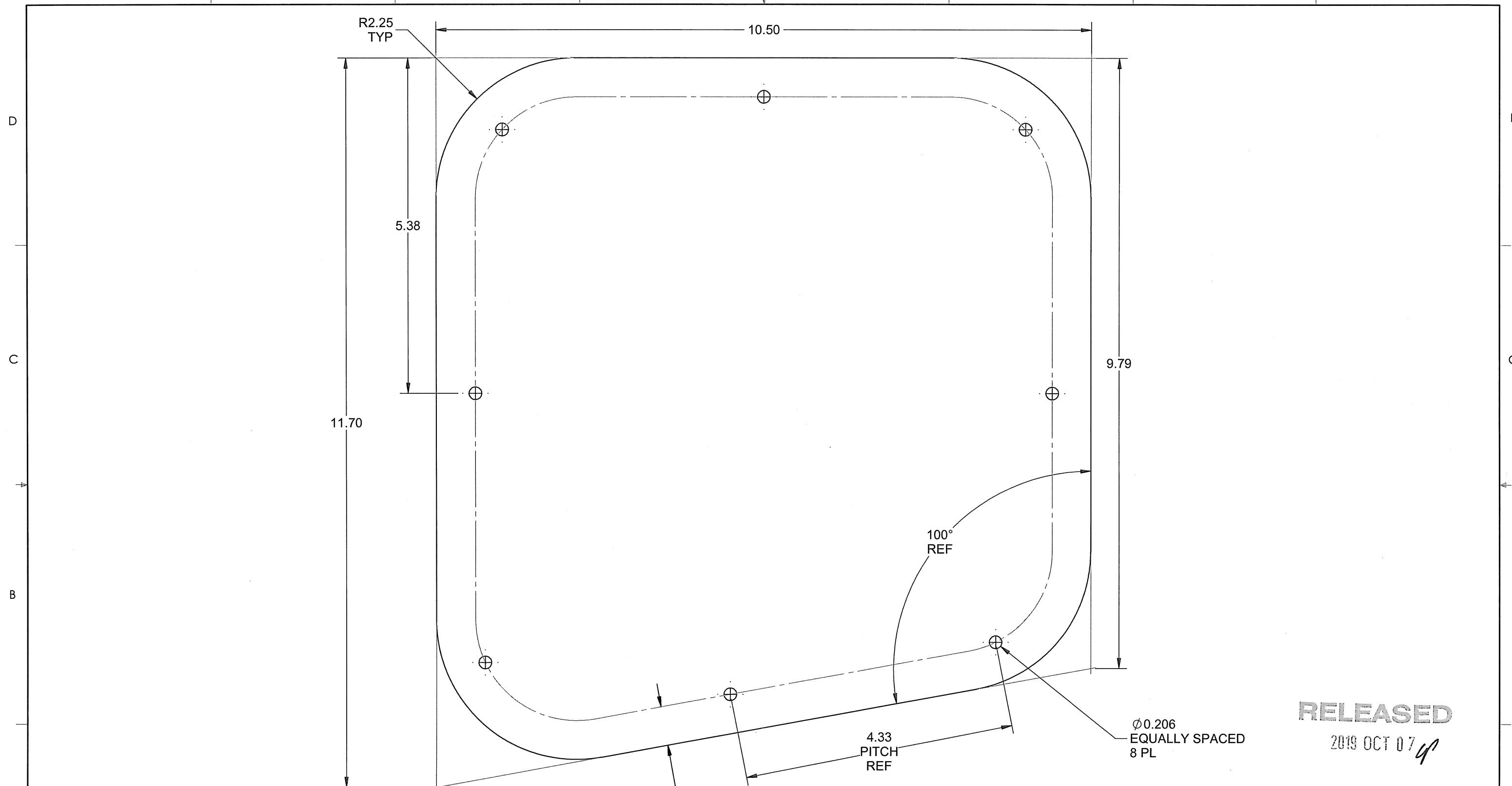
APPROVED

DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	PM	
CHECKED	SAD	
MFG. APPR.	JFS	
APPROVED	VS	
DE APPR.	DS	
DRAWING NO.	REV. D	
D4577	SHEET 2 OF 8	
TITLE	SCALE	
ACCESS PANEL	NTS	
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8 7 6 5 4 3 2 1



8 7 6 5 4 3 2 1



NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.125 THK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.125
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.32 lbs
- 8) MANUFACTURE PART PER D4577-3-D.DXF

D4577-3 MIDDLE ACCESS PANEL

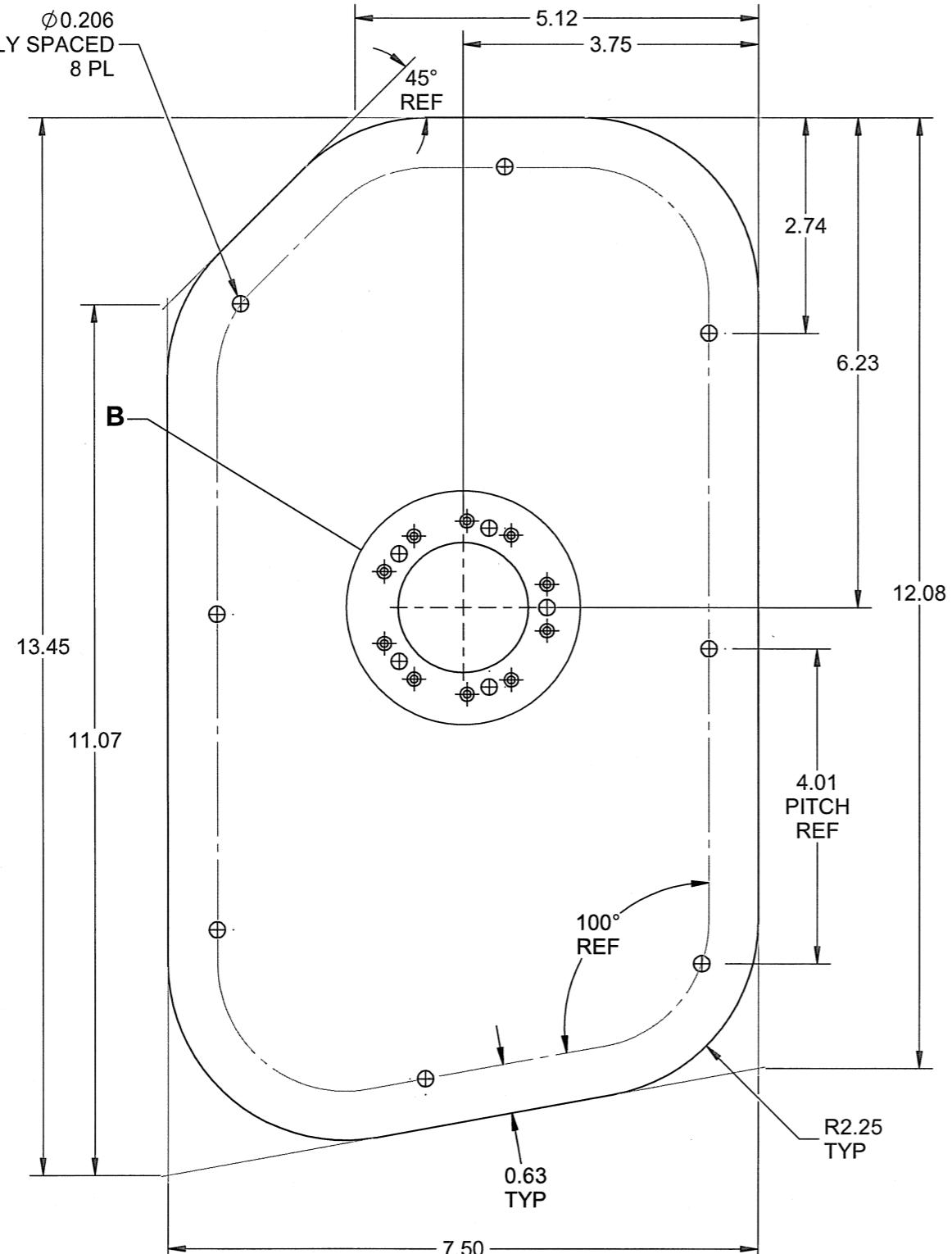
APPROVED

DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	PM	
CHECKED	SAD	DRAWING NO.
MFG. APPR.	JFS	REV. D
APPROVED	VS	D4577
DE APPR.	DS	SHEET 4 OF 8
DATE	19.02.05	TITLE SCALE NTS ACCESS PANEL



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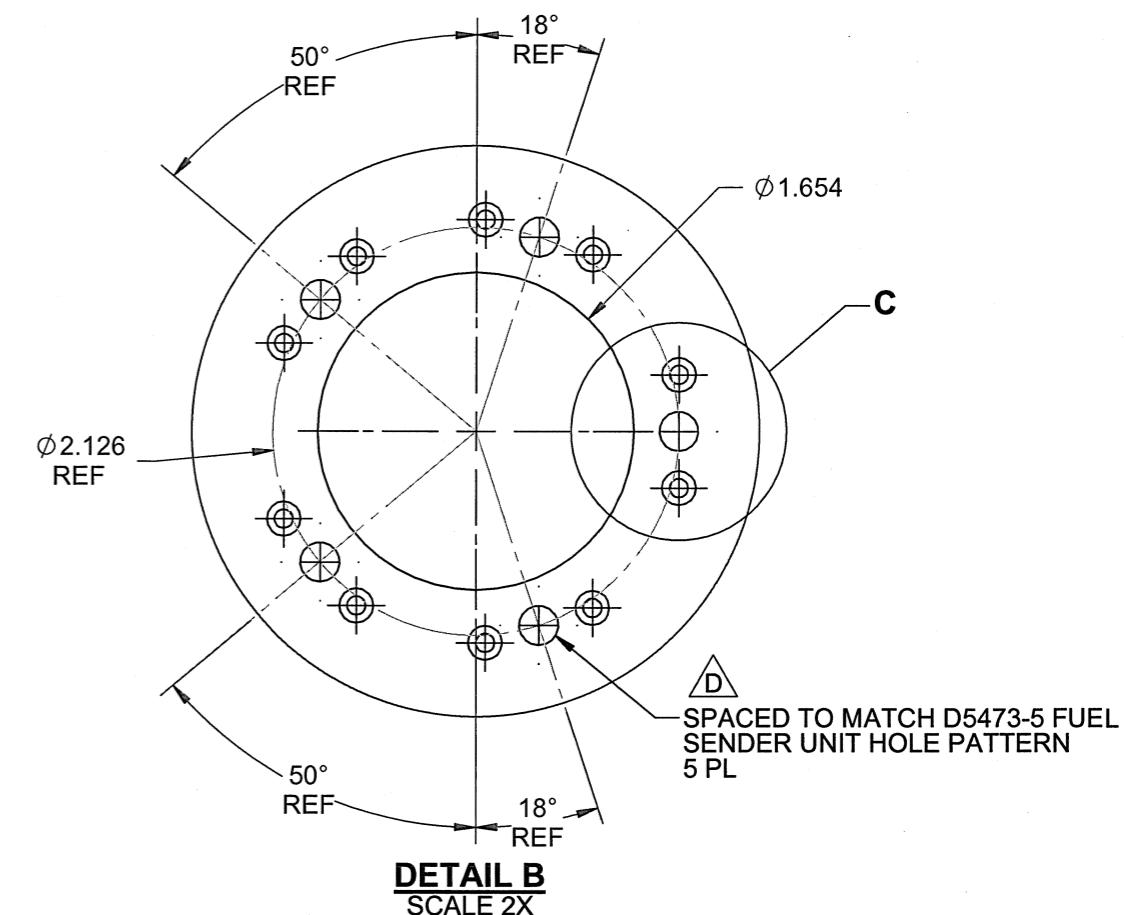
2019 OCT 07 gp



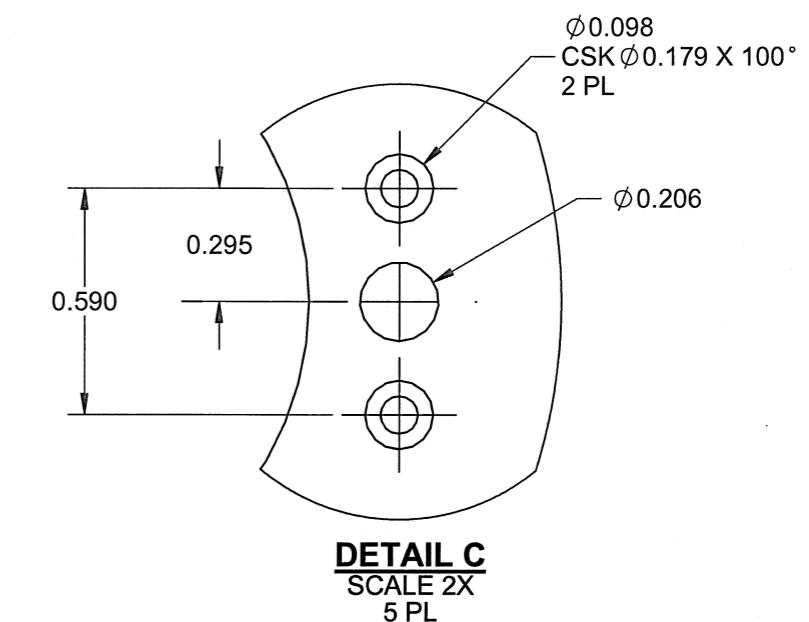
D4577-5 FWD ACCESS PANEL

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.125 THK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.125
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.06 lbs
- 8) MANUFACTURE PART PER D4577-5-D.DXF



DETAIL B
SCALE 2X



DETAIL C
SCALE 2X
5 PL

RELEASED

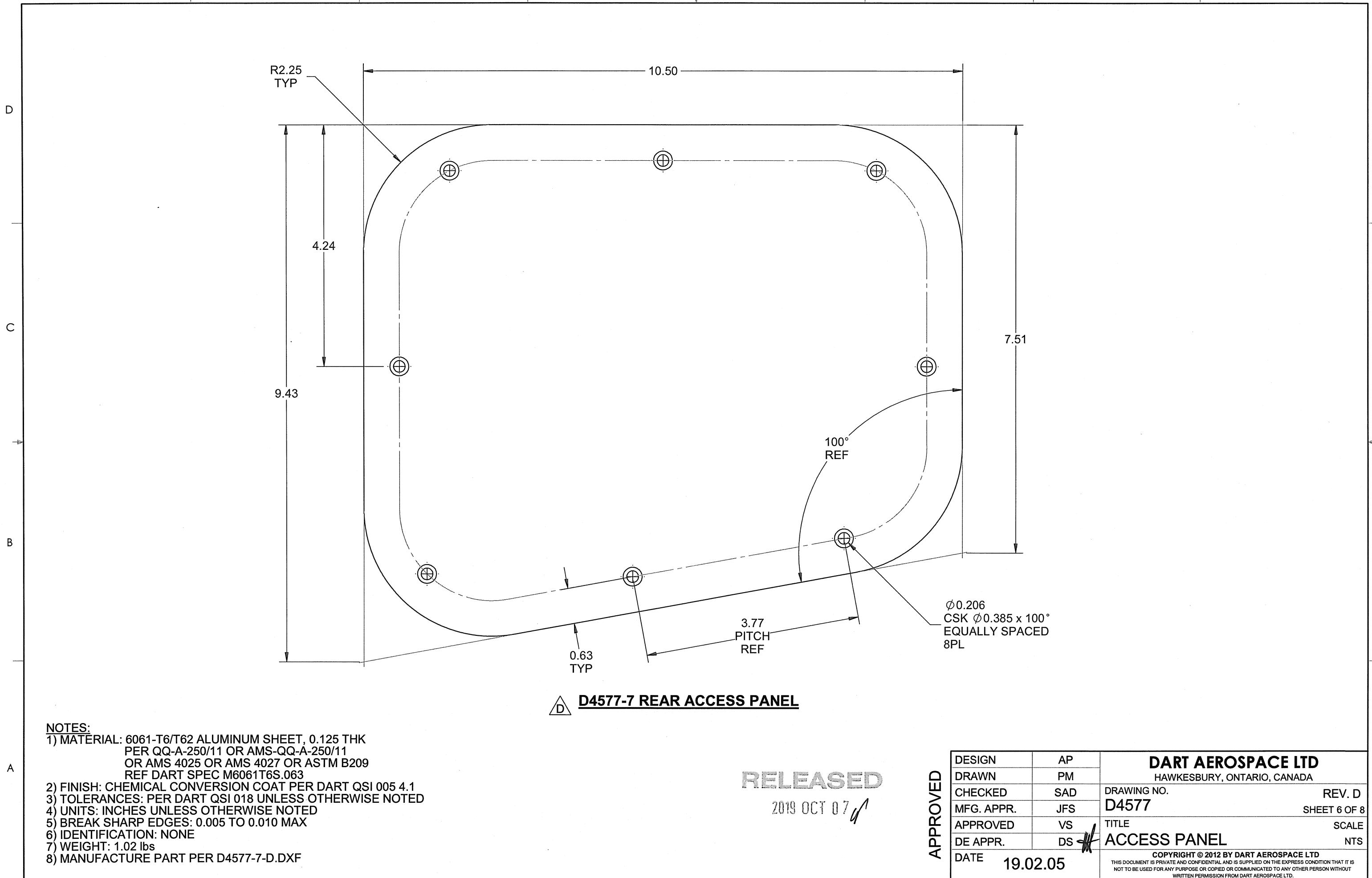
2019 OCT 07 /

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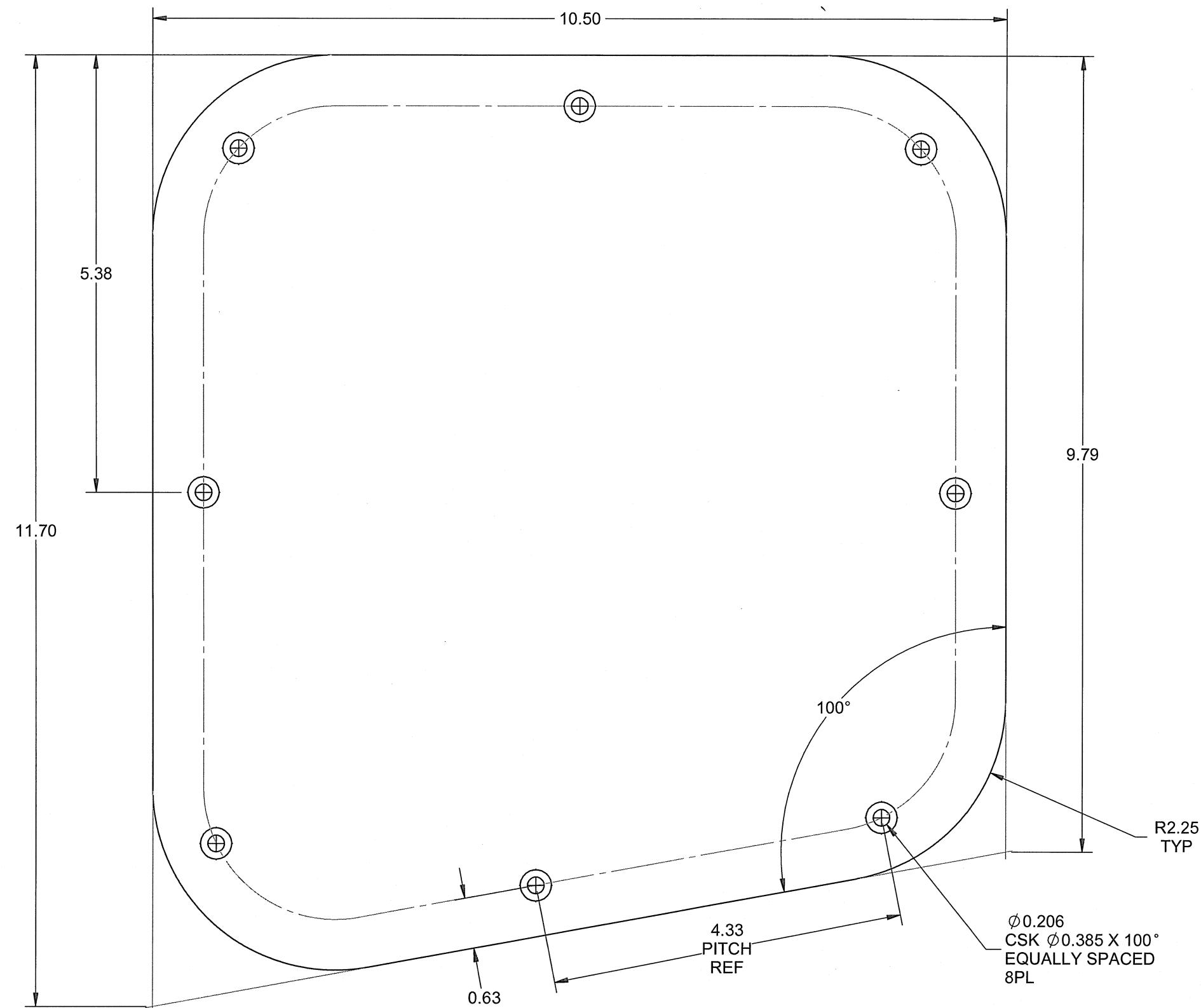
DESIGN	AP	DART AEROSPACE LTD
DRAWN	PM	HAWKSLEY, ONTARIO, CANADA
CHECKED	SAD	DRAWING NO.
MFG. APPR.	JFS	D4577
APPROVED	VS	REV. D
DE APPR.	DS	SHEET 5 OF 8
DATE	19.02.05	SCALE
		NTS

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8 7 6 5 4 3 2 1



8 7 6 5 4 3 2 1



NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.125 THK PER QQ-A-250/11 OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209 REF DART SPEC M6061T6S.125
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.31 lbs
- 8) MANUFACTURE PART PER D4577-9-D.DXF

D D4577-9 MIDDLE ACCESS PANEL

APPROVED

DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	PM	
CHECKED	SAD	DRAWING NO.
MFG. APPR.	JFS	D4577
APPROVED	VS	REV. D
DE APPR.	DS	SHEET 7 OF 8
DATE	19.02.05	TITLE SCALE NTS ACCESS PANEL

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